



Dart Aerospace Ltd.
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D2143
Job Sheet 214620



Part No: D2143

Job Qty: ~~12~~ pcs

DAS
21
9-89

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/28/20

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 11/25/20

Description: SIOP

Type: Stock

Note: DWG REV C1 IPP C 00.05.18 Added inspection level 8 EC IPP Rev:D Now on WaterJet 06-10-15 JLM

Ship Via:

Bill of Materials

Job Routing

[illegible]

DEC 01 2020 **DAS 40**

Plex 10/28/20 10:04 AM Dart.Renwick.Jennife

				QC 8 - 82		
140	Small Fab - Brake NC - B4B	12 pcs	11/24/20	0.25 0.48	Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	DEC 04 2020
150	QC 5	12 pcs	11/24/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DEC 04 2020 40
					QC 5 - 61	DAS 2-30
					QC 5 - 81	
					QC 5 - 82	
160	Handfinish - 1-1 Chemical-B4B	12 pcs	11/24/20	0.00 0.26	Handfinish - 1 - 1 - B4B	BEB 04/12/2020
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
				Plex 10/28/20 10:04 AM Dart.Renwick.Jennifer		

170 Powdercoat - 1 White GI(A)- B4B	12 pcs	11/25/20	0.00 0.20	Powdercoat - 1 - B4B	
<i>M 25469</i> <i>START: 10:55</i> <i>O.V.T. 320°</i> <i>FINISH: 11:25</i>				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	<i>20-12-7</i>
				Powdercoat - 4 - B4B	
				Powdercoat - 5 - B4B	
				Powdercoat - 6 - B4B	
				Powdercoat - 7 - B4B	
				Powdercoat - 8 - B4B	
				Powdercoat - 9 - B4B	
				Powdercoat - 10 - B4B	
180 QC 3	12 pcs	11/25/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
				QC 3 - 47	
190 Packaging 3-1 - Stock - B4B	12 pcs	11/25/20	0.00 0.00	Packaging 3 - 1 - B4B	
<i>15 pcs</i> <i>MKD</i>				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	

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				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
200 QC 21 - SA	12 pcs	11/25/20	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89
				QC 21 - SA - 70	
				QC 21 - SA - 9	
				QC 21 - SA - 77	
				QC 21 - SA - 28	

DEC 08 2020

Part Op 100 - 1-Cut as per Dwg D2143

Descriptions: 120 - (QC8- Inspect parts - second check)

140 - (Bend/Assemble as per dwg) Bend as per Dwg D2143

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Chemical Conversion Coat per QSI005 4.1)

170 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE:

FINISH TIME: _____

180 - (QC3- Inspect Part Finish)

190 - (Identify as per dwg & Stock Location: _____)

200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.040	5052-H32 .040 Sheet	.7920 sf (.066 ea)	100-Waterjet - Flow - 1	S275576

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M5052H32S.040	1	22	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	0.340Inches $\pm$ 0.010	0.350 0.330		.338
2	Hinge Bracket	0.625Inches $\pm$ 0.010	0.635 0.615		.626
3	Hinge Bracket	1.000Inches $\pm$ 0.010	1.010 0.990		.999
4	Hinge Bracket	0.063Inches $\pm$ 0.010	0.073 0.053	Radius	.063
5	Hinge Bracket	2.656Inches $\pm$ 0.010	2.666 2.646		2.659
6	Hinge Bracket	3.317Inches $\pm$ 0.010	3.327 3.307		3.325
7	Hinge Bracket	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter	ϕ .257
8	Hinge Bracket	0.171Inches + 0.005 - 0.000	0.176 0.171	Diameter	ϕ .171
9	Hinge Bracket	1.660Inches $\pm$ 0.010	1.670 1.650		1.657
10	Hinge Bracket	2.844Inches $\pm$ 0.010	2.854 2.834		2.851
11	Hinge Bracket	1.659Inches $\pm$ 0.010	1.669 1.649		1.661
12	Hinge Bracket	0.125Inches $\pm$ 0.010	0.135 0.115	Radius	.125
13	Hinge Bracket	2.312Inches $\pm$ 0.010	2.322 2.302		2.311

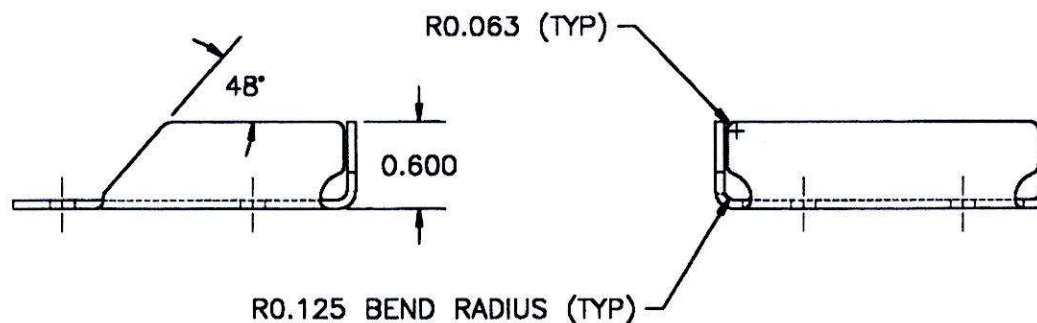
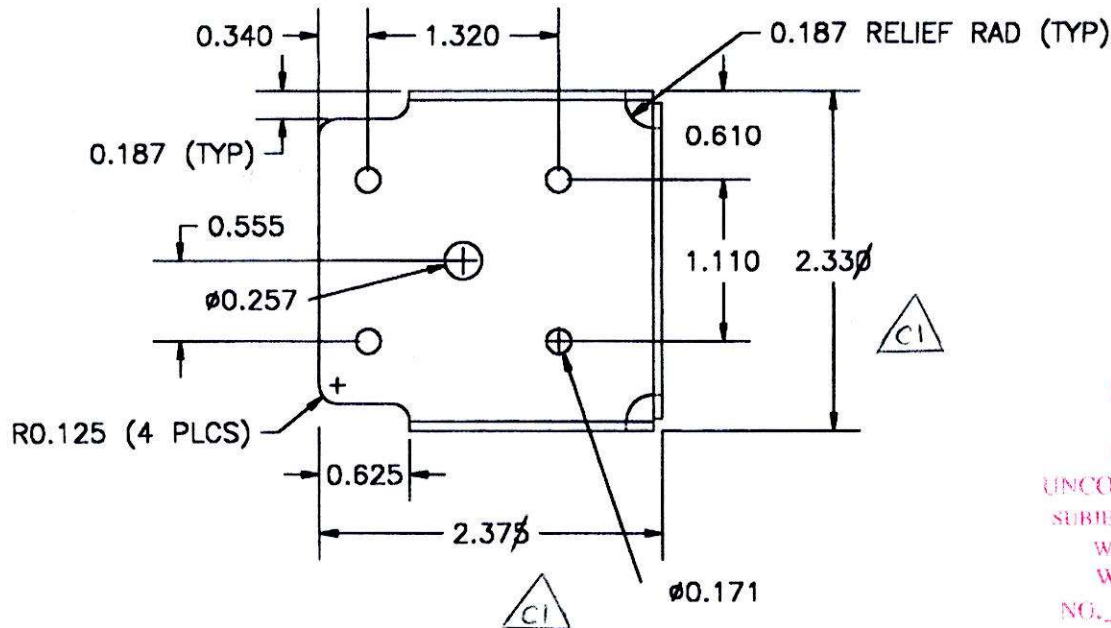
Plex 10/28/20 10:04 AM Dart.Renwick.Jennifer



RELEASED
760620 (50)

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. C
J BRADLEY	K HAND		
CHECKED B	APPROVED B	DRAWING NO. D2143	SHEET 1 OF 2
DATE 92.07.10		TITLE HINGE BRACKET	SCALE
B	96.06.06	ADD FLAT PATTERN	
C	96.06.13	MATERIAL WAS 2024-T3 .063 THICK	
C1	Art 04.06.15	UPDATE DIMENSIONS	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 214620

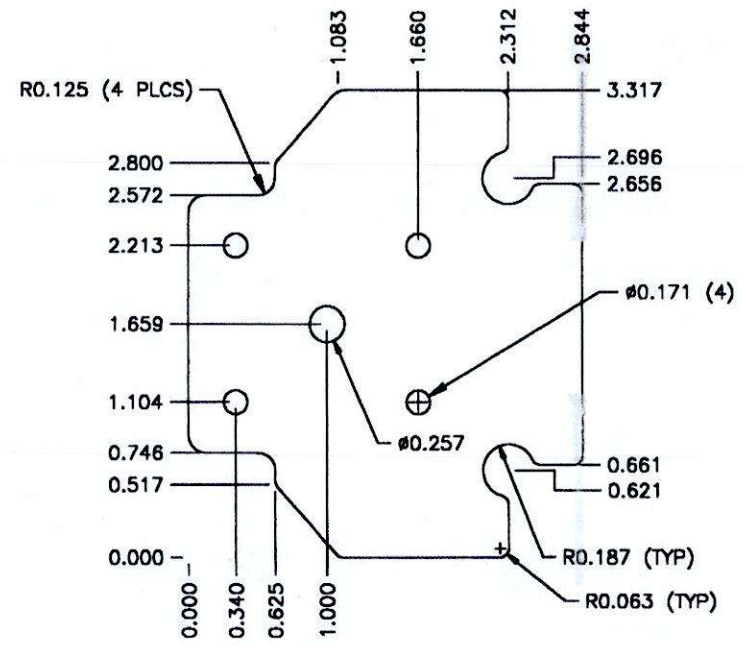


MATERIAL: 5052-H34, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
J BRADLEY	K HAND	DRAWING NO.	REV. c
CHECKED	APPROVED	D2143	SHEET 2 OF 2
DATE	TITLE	SCALE	
95:10:18	HINGE BRACKET FLAT PATTERN	1:1	

RELEASED
96-6-20



MATERIAL: 5052-H34, 0.040 THICK GRAIN ALONG 3.317

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

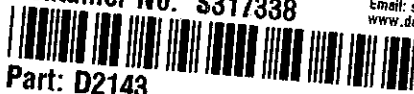
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :	MRB (QS1042)		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S317338



Part: D2143

Job No: 214620

Serial No/Batch: S317338

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/01/20